

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013688**Date Inspected:** 30-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

<b>CWI Name:</b>	Mr.Zhao Chen Sun/Mr.You Qi Guo			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

TOWER TRAIL ASSEMBLY AREA:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as East Tower Shear Splice Plate. The weld designations reviewed are as follows:-  
ESD1-A167A/H-6,7,8A/B

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as South Tower Shear Splice Plate. The weld designations reviewed are as follows:-  
SSD1-A111A/H-2

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ED1-A27B/E-55 located on East Shaft to North Shaft Shearing Plate Bearing

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Stiffener Plate. Welder is identified as 040367.ZPMC QC is identified as Mr. Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ED1-A27B/E-56 located on East Shaft to North Shaft Shearing Plate Bearing Stiffener Plate. Welder is identified as 057244.ZPMC QC is identified as Mr. Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ED1-A27B/E-63 located on East Shaft to North Shaft Shearing Plate Bearing Stiffener Plate. Welder is identified as 057266.ZPMC QC is identified as Mr. Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This QA inspector observed the following work in progress:

ZPMC performed buttering on South Shaft Skin "E" Bearing Stiffener (SSD1-SA16F/G-31).The Buttering area is 10mm thick. The material is A 709M Grade 345 Non-SPCM. Welder is identified a 040581.ZPMC CWI is identified as Mr. Gang Liang Zhu. SMAW welding was been performed against Weld repair report T-WR3209. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---